

Date: Thursday, 3/13/2008 10:20:39 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: MOUNTING LUG		
Job Number	37933			Part Number	: D32351		
Estimate Number	10428			Drawing Number	: D3235 REV A		
P.O. Number				Project Number	: N/A		
This Issue	3/13/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	MACHINED PARTS	Due Date	4/4/2008	Qty:	100
Previous Run	33249			Um:	Each		
Written By	<u>1080313</u>						
Checked & Approved By							
Comment	Est A 04.04.19 New issue KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
		Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s) Lug Extrusion D2423 extrusion Batch: <u>B33310</u> C 108/03/17
2.0	BAND SAW	BAND SAW <i>N/A</i> Cut at Metree
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 <i>Issue P.O 5918</i> Machine per drawing D3235 Rev.A Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA369 and Dwg D3235 2-Identify as D3235-1 3-Deburr and Tumble <i>RG</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>Receive & inspect parts as they come off machine Ensure C3/C attached</i> Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>JG 4/4/24 (100)</i>
5.0	QC5	SECOND CHECK <i>Inspect head S</i> Comment: SECOND CHECK <i>SG 4/4/24 (100) (cont)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1



HAND FINISHING RESOURCE #1

Counted
100X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-6

08/04/28

7.0 QC5

INSPECT WORK TO CURRENT STEP



B37933
D32351
29/04/2008

Comment: INSPECT WORK TO CURRENT STEP

M-6 08/04/28

8.0 POWDER COATING

POWDER COATING



S.143 10.17
#1 319.1 F
#2 --- F
#3 --- F
#4 --- F

M107550

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

MF 08-04-

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



BLL 08-04-30

Comment: INSPECT POWDER COAT

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 471

AS 08/05/01 (red)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/05 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

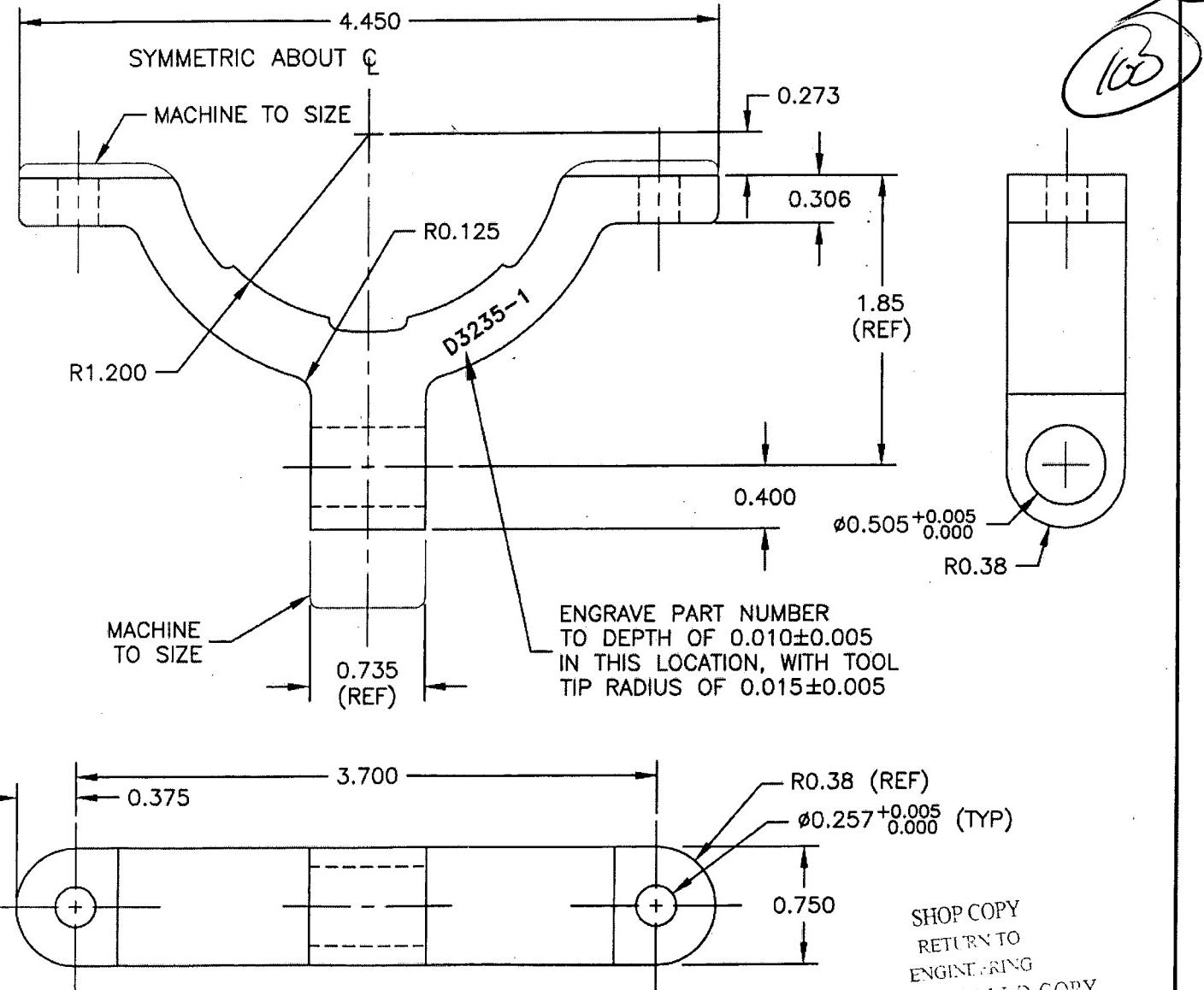
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	4P	DRAWN BY	4P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	APPROVED	✓	DRAWING NO. D3235 REV. A
DATE	04.03.02	TITLE	MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE		

RELEASED
04.04.05 ✓**D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000–0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 37933



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
100	D3235-1	Mounting Lugs	5918

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

[Signature]
METEC Metal Technology Inc.

Denise Robinson

Vankleek Hill, April 24, 2008